

Split

Work Order ID 62494

Thursday, September 30, 2010 2:31:46 PM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010 Start Qty: 6.00

Required Date: 9/30/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 10-9-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

0.00

120



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

EB 10/11/29 (5)

EB 10/11/29 (5)

(x5)

8/10/11/29

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Item ID: D3909-041

Revision ID:

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Start Date: 9/30/2010 Start Qty: 6.00

Required Date: 9/30/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location SID

0.00

Memo

0.00

10/1/29

SP

(50)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-11-29

MF
10-11-29

Picklist Print

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Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2690-6



Lanyard Assembly

Manufactured

No

100

Each

31.0000

1

6

Location

ST020

Loc Qty

31

Loc Code

59960

6

61382

25

Manufactured

No

100

Each

15.0000

2

12

Location

ST095

Loc Qty

15

Loc Code

57824

8

59155

7

Manufactured

No

100

Each

13.0000

1

6

Location

ST095

Loc Qty

13

Loc Code

59209

1

59442

12

Manufactured

No

100

Each

1.0000

1

6

Location

ST095

Loc Qty

1

Loc Code

58240

1

D3909-5



Eyebolt Stud

Manufactured

No

100

Each

1.0000

1

6

Location

ST095

Loc Qty

1

Loc Code

58240

1

EP 510/11/29

EP 510/11/29
B64066 (7x)

EP 510/11/29
B58340 (4x)

EP 510/11/29

B62492 (6x)

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Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

X D3910-1
Crosstube Lug

Manufactured No

100 Each

9.0000

2

12

Location

Loc Qty

Loc Code

st507

9

59349

8

59708

1

D3917-1



Washer

Manufactured No

100 Each

72.0000

2

12

Location

Loc Qty

Loc Code

ST065

40

57821

40

ST096

32

60170

32

AN3C12A



Bolts

Purchased No

100 Each

62.0000

4

24

Location

Loc Qty

Loc Code

ST351

62

112314

8

114761

11

115392

23

115594

20

AN3C13



Bolt

Purchased No

100 Each

70.0000

1

6

Location

Loc Qty

Loc Code

ST351

70

114304

26

114714

44

9/30/11/29
B62009 (4x)
B62944 (6x)

9/30/11/29
B60170

9/30/11/29
M116022 (24x)

9/30/11/29
6

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Shop Packet Print

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Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

X MS17984-C413

Purchased

No

100

Each

18.0000

1

6



PIN, QUICK RELEASE



Ep 10/11/29
M116081 (5x)

Location

Loc Qty

Loc Code

ST297

4

114340

4

ST314

14

114523

1

114886

13

4M18
MS20615-4M20

Purchased

No

100

Each

266.0000

3

18



RIVET



Ep 10/11/29

Location

Loc Qty

Loc Code

ST323

266

114808

96

115054

170

AN310C3

Purchased

No

100

Each

70.0000

1

6



Castellated Nut



Ep 10/11/29

Location

Loc Qty

Loc Code

ST349

70

114304

20

114714

50

6

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Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd



Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

MS21043-3

Purchased

No

100

Each

2,599.000

4

24



Nut



EP 10/11/29

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2523

111383

46

112314

2477

MS24665-151

Purchased

No

100

Each

617.0000

1

6



Cotter Pin



24
EP 10/11/29

Location

Loc Qty

Loc Code

ST309

617

17566

617

NAS1149C0332R

Purchased

No

100

Each

443.0000

8

48



Washer



6
EP 10/11/29

Location

Loc Qty

Loc Code

ST297

443

113524

10

113737

150

115000

125

115698

158

M115832 (48x)

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Picklist Print

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Work Order ID: 62494

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd



Start Date: 9/30/2010

Required Date: 9/30/2010

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0363R

Purchased

No

100

Each

5,838.000

2

12



Washer



EP 10/11/29

Location

Loc Qty

Loc Code

ST297

5838

113524

188

113644

150

113889

500

114742

5000

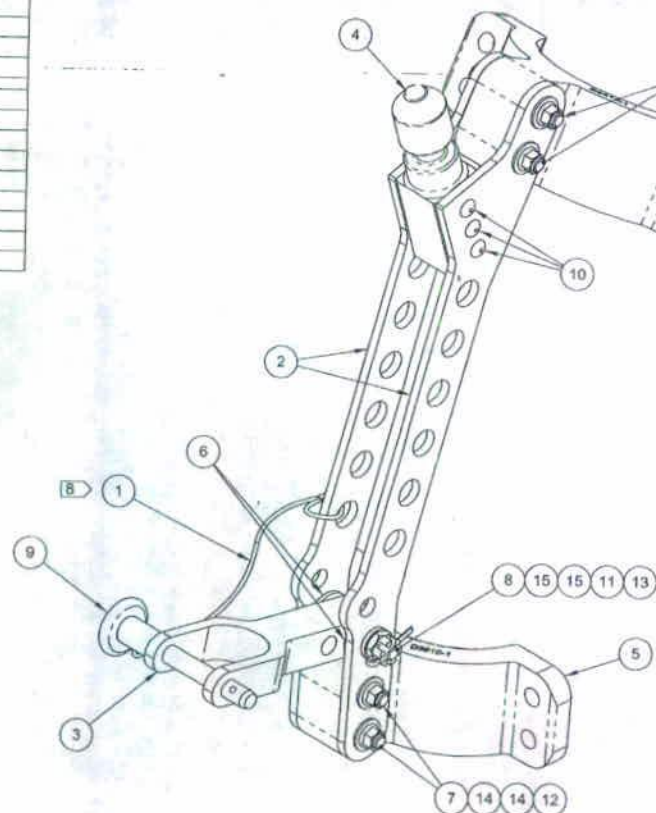
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Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20015-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
REVISIONS
UNCONTROLLED COPY
SUBJECT TO AND NEW
WITHOUT
WORK ORDER
NO. *62494*
BS10-9-30

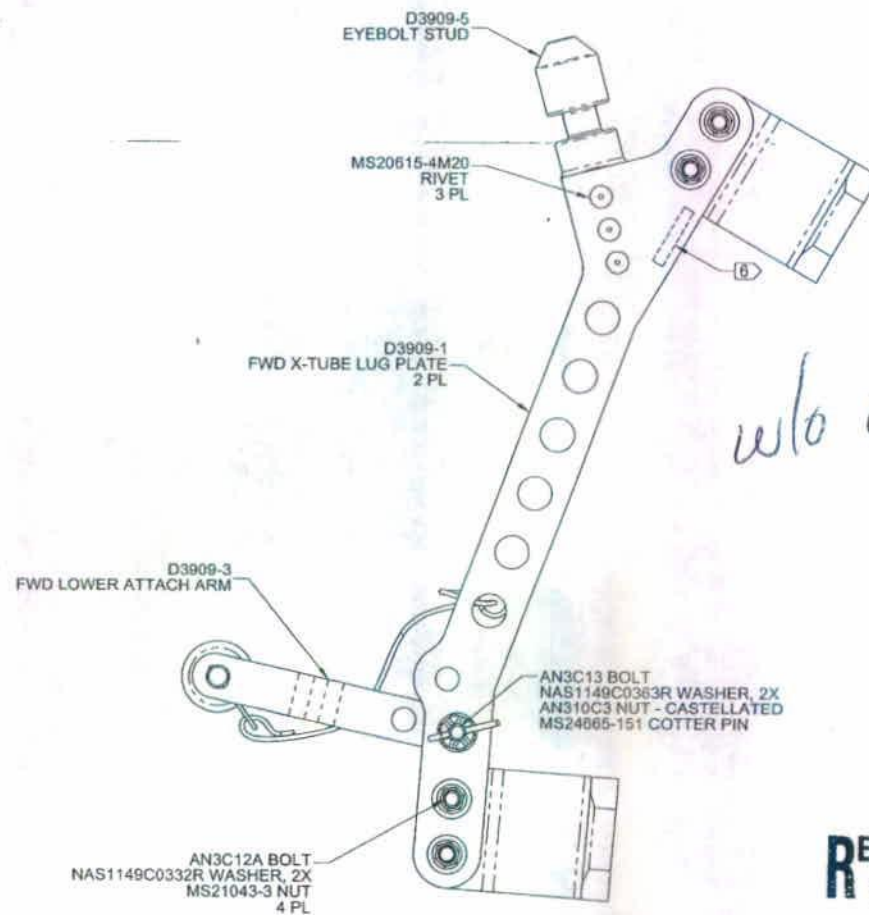
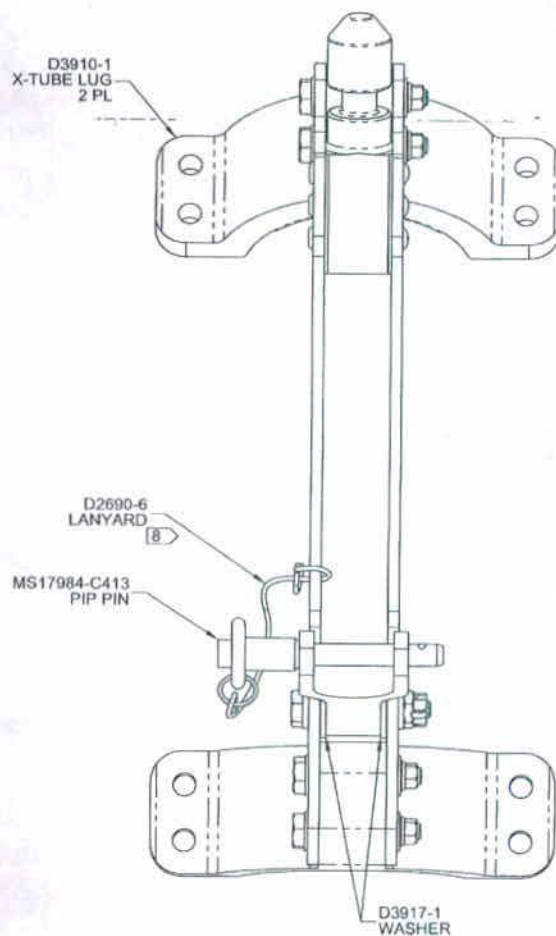
RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-S), 2.88 WAS 2.88 (ZN B5-S); WEIGHT AFFECTED (D3909-041/5)	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED, SECTION A-A & DIM Ø.050 REMOVED, SIDE VIEW ADDED, DIM: 2.88 WAS 2.58 REF. 1.30 WAS 1.00, 0.250 WAS 0.220, 80.00 WAS 80.05, WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.06.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3909** REV. C
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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w/o 62494

D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	<small>COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE EXPRESS OR IMPLIED UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	